

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027927**Date Inspected:** 09-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Jesus Cayabyab**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI met with Quality Control Inspector (QCI) Jesus Cayabyab and witnessed the continuing excavation of Electro-Slag Weld (ESW) S (S-041). The QAI and the QCI noted that the contractor will be clearing several indications previously reported from an Ultrasonic Testing (UT) survey of the weld. The QAI and QCI reviewed the areas and noted that excavation work performed Friday will need additional carbon arc gouging. The QAI and the QCI witnessed the excavation of the indications. At approximately 24mm depth, grinding of 1mm to 2mm intervals were performed and the excavated weld was visually examined and magnetic particle testing (MT) was performed by the QCI. The QAI noted that at 32mm deep, there were no relevant indications observed with MT. The Structural Materials Representative (SMR) Aaron Prchlik and the contractor's Welding Quality Control Manager (WQCM) Jim Bowers were present and there was agreement that the reported UT indications have been removed and were not observed during the excavation procedure. The QAI noted that the final dimensions of the upper excavation (completed Friday) are Y=7435 Length = 260mm Depth = 18mm and Width = 35mm. The lower excavation is Y= 6995 Depth 32mm Length = 400mm and Width = 45mm. The QAI was informed that the repair welding of the excavation has not been scheduled yet. See the attached photos.

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Summary of Conversations:

The QAI relayed the status of the UT inspection / excavation to the QAI Lead Bill Levell. There were other conversations between the QAI and ABF personnel regarding the weld excavation. The QAI and the QCI Jesus Cayabyab had conversations regarding the ESW scanning and excavation inspection. The QAI did not monitor any welding or repairs during this shift. Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer